W	ork	O	rder	ID	661	92
* *	UIR	v	luci	w	wwi	74

Monday, February 07, 2011 11:57:00 AM



Page 1

Item ID:

D3296-1

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Required Date: 2/22/2011

Door Panel

2/8/2011

QC:

Start Qty: 6.00 Req'd Qty: 6.00

Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: //-02-0 7 Tooling:

0.00

SPC (Y/N):

Date:

Date:

Run

Qty

Start

Stop



Stop

Sequence ID/ Work Center ID

Operation Description

Revision Nbr

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

Draw Nbr D3296

Rev A

100

Waterjet

FLOW CNC Waterjet 200. 4606

FLOW WATER JET Memo

1-Cut as per Dwg D3296 Deburr if necessary

□Dwg Rev:

0.00 A Prog Rev: A D2-

B 11-2-17

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B1-7-17

120

Memo

QC8- Inspect parts - second check

0.00

0,00 Enlos117

Quality Control

Dart Aerospace Ltd

	оораоо									
W/O:			WO	RK ORDER CHANGI	ES					
DATE	STEP	PRO	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		•								
Part No		PAR #:		-						
	Re	esolution:	Disposition	n:	_ QA: N/C	Clos	ed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	CR)				
		Description of NC		on B		Verification		Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate		ion C	Chief Eng	QC Inspector
		, remarks								
					ļ					

Work Order ID 66192

Monday, February 07, 2011 11:57:00 AM



Page 2

Item ID:

D3296-1

Accept

Setup Start

Stop



Revision ID:

Item Name: Start Date:

Door Panel

2/8/2011

Start Qty: 6.00 Rea'd Otv: 6.00

Cust Item ID:

Customer:

Reference:

Process Plan:

Date: _____

Tooling:

Date:

Tool ID

Run

Reject

Qty

Accept

Qty

Start

Reject

Number



Required Date: 2/22/2011

QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop



Insp.

Stamp

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

140

Operation Description

Small Fab

Memo Deburr

Set Up/ **Run Hours**

0.00

0.00

HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

0.00

0.00

6 \$ Hulod 27

150

Quality Control

QC3- Inspect Part Finish

0.00

Memo

Memo

0.00

6 BR 11-02-22

Dart Aerospace Ltd

W/O:	-		WO	RK ORDER CHANG	ES	, ,			
DATE STEP		PRO	PROCEDURE CHANGE						Approval QC Inspector
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Part No	:	PAR #:	Fault Cated	orv:	NCR: Yes	s No DO	QA:	Date:	
		solution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section	on B Sign		fication		
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Dat		ction C	Chief Eng	QC Inspector
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Work Order ID 66192

Monday, February 07, 2011 11:57:00 AM



Page 3

Item ID:

D3296-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 2/22/2011

Door Panel

2/8/2011

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Date: **Tooling:**

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Start

Run



Stop

Sequence ID/

Work Center ID

160

Packaging

Packaging

Operation Description

QC:

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty , Number

Insp. Stamp

170

QC

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

Dart Aerospace

Dail Aoi	p								
W/O:		,	W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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3									
Part No:		PAR #:	Fault Cate	egory:	NCR: Yes	s No DG	A:	_ Date: _	<u>.</u>
	R	esolution:	Disposition	on:	QA: N/C	Closed: _		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	tion B Sign		ication	Approval	Approval
		Section A	Chief Eng	Chief Eng	Dat		tion C	Chief Eng	QC Inspector
								1	
	l								

H:\fFQ=MS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, February 07, 2011 11:56:57 AM

Work Order ID: 66192

Parent Item:

D3296-1

Parent Item Name: Door Panel



Start Date: 2/8/2011

Required Date: 2/22/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP C□05.10.14□Added step 14□KJ/EC□ IPP Rev:D Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	31.9270	0.6596	4.165895			

Loc Qty Loc Code Location MAT22 31.927 114351 31.927

						·			
W/O:	WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
in									
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C Cld	sed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMA	ANCE (NCR)			
DATE	CTED	Description of NC			verification Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	tion C	Chief Eng	QC Inspector

^{*} H:\fF_RMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	66142
Description: Door Panel	Part Number:	D3296-1
Inspection Dwg: D3296 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.08	+/-0.030	5.088	75		VEOL	
R0.06	+/-0.030	,06	>		R.G.	
0.300	+/-0.010	. 247	8		v	
Ø0.128	+0.005/-0.000	1761,	৮		V	
16.400	+/-0.005	16.400	7		T 1801	
0.300	+/-0.010	_307_	×	•	V	
.13.400	+/-0.005	13.400	8		T	
17.00	+/-0.030	17.00	15		7	
14.18	+/-0.030	14.18	7	-	7	
0.300	+/-0.010	-300	7		U	
0.063	+/-0.010	1063	>		V	
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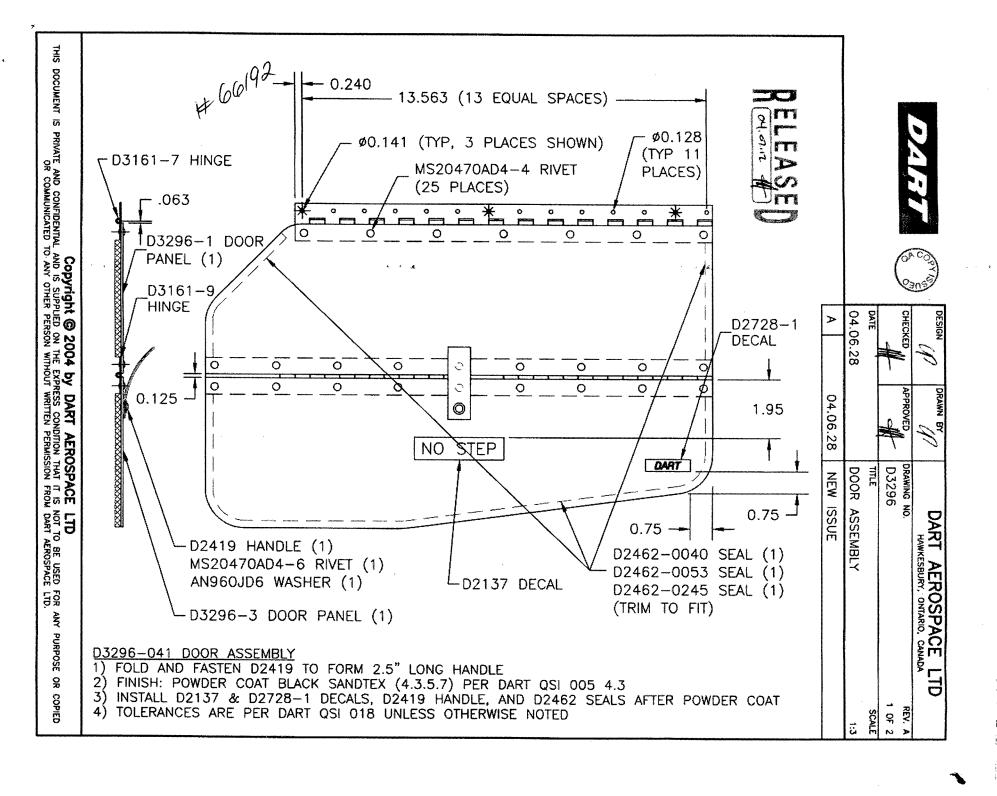
Measured by:	Æ	Audited by:	5	Prototype Approval:	N/A
Date:	11-6-17	Date:	11/00/12	Date:	N/A

Rev	Date	Change		Revised by	Approv <i>e</i> d
Α	04.08.24	New Issue	P/O D3296-041	KJ/JLM	Chil
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D	art	Αe	ro	sp	ac	е	Ltd
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W/O:			WORK ORDER (WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No):	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date: _	1			
	Re	esolution:	Disposition:	QA: N/C C	losed:		Date: _				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section 6	3	Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto			
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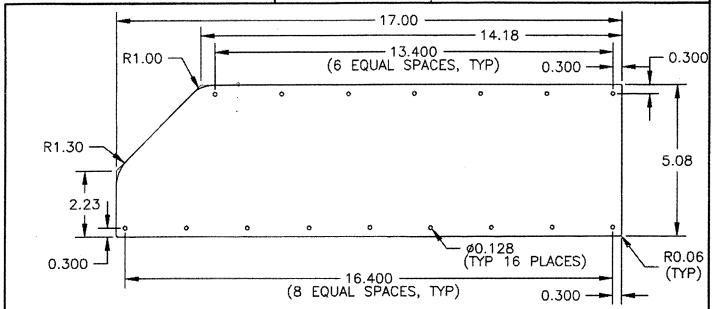
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Part No	•	PAR #:	Fault Cat	egory:	NCI	R: Yes	No DQ	A:	Date: _	
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NCR:			WORK OR	DER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action	Section B	Ciam 0	Verific		Approval	Approval
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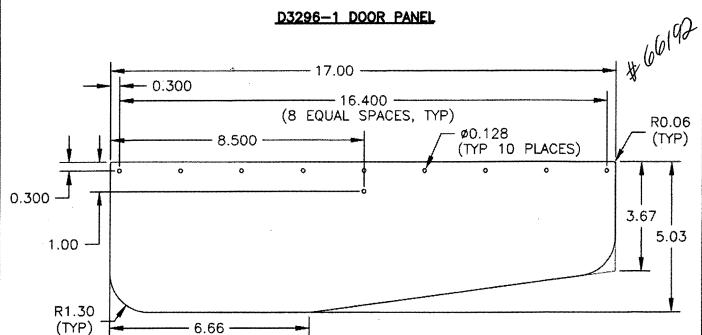




i	DESIGN (DRAWN BY	DART AEROSPA(HAWKESBURY, ONTARIO,	
	CHECKED	APPROVED	DRAWING NO.	REV. A
	#	 	D3296	2 OF 2
	DATE		TITLE	SCALE
	04.06.28		DOOR ASSEMBLY	1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF DART SPEC. M2024T3S.063)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:			WO	RK ORDER CHANGES					-
DATE	STEP	PRC	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section E Action Description Chief Eng	Sign & Date		cation tion C	Approval Chief Eng	Approval QC Inspector
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